## "APPROVED FOR RELEASE: 03/14/2001 CIA-RDP86-00513R001757130011-5

	Brus', B. I., Zubkov, G. S., Enlagin, V. D., Bacala, V. E., Bacalasov, Y. B., Bacalasov, T. E., Berniation of T. Totaleria, B. I., Determination of T. Internal Strusses According to the Bath of the Courts) Points Savodataya laboratoriya, 1959, Vol 25, Hr 6, pp 1005-1006 (The most reliable determination sechado of the absolute interference of sheet setal constructions are the trepressions those sead on entiting out smaller sections of the structure states for the determination of attention and is smallens accincted the first execution of the gravest of the gravest importance in the structure state for the determination of attention of the structure state for the determination of attention of the structure state of the gravest importance in large seas of the first executive states. The designed instrument consists of an option	A disk of seel with three comes arranged forms a delication of shear all of (form the beauter) in the made of a hard maley (form the beauter) instruments are now surface to the same natural as that of analysis and the latter is and of the same natural as that of the taste heat structure and both are kept at the same temperate setal structure and both are kept at the same temperate for the same and point are kept at the same temperate for the same temperate and form the same setal area for the same setal setal area for the same setal setal setal area for the same setal setal setal area for the same setal s	z figures.	•	
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SOV/122-59-5-11/32

AUTHOR:

Tsukerberg B.I. Engineer

TITLE:

Selection of an Efficient Shape of the Nozzle in an Electric Metallising Gun (Vybor ratsional noy

formy sopla elektrometallizatora)

PERIODICAL: Vestnik mashinostroyeniya, 1959, Nr 5, pp 36-38 (USSR)

ABSTRACT:

Present day Russian metallising guns (types EM-3A and EM-6) use cylindrical nozzles which allow only an increase of pressure as a method of raising the particle velocity. Even so, this velocity is limited to a maximum value between 120 and 250 m/sec. To increase this velocity, cylindrical, convergent, stepped and divergent nozzles (Fig 1) were tested and compared. Rather than measuring the particle speed, the properties of the resulting metallised layer were used as a criterion. Two hollow cylindrical specimens, each tapped at one end, were bolted together and the cylindrical surface was metallised, after which the central bolt was removed and end fittings were screwed in to fit into a tensile machine so that the metallised coat at the butt joint could be pulled on its own. Only the cylindrical and divergent nozzles

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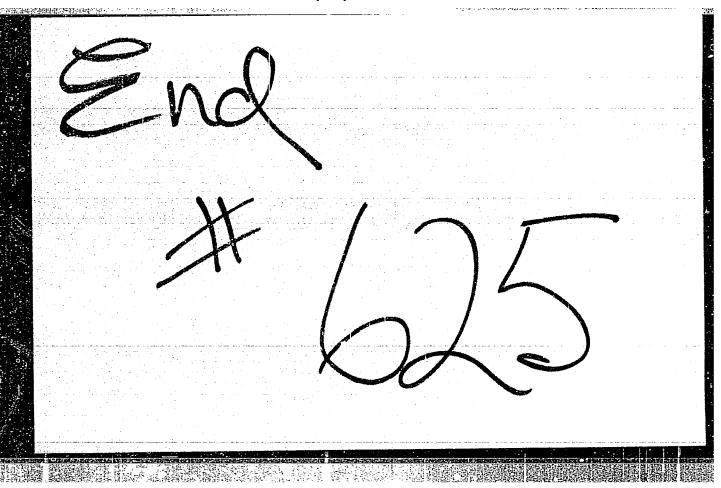
Selection of an Efficient Shape of the Nezzle in an Electric Metallising Gun

proved promising and were examined in detail. The divergent nozzles gave a tensile strength by about 12% greater than the cylindrical nozzle. The microhardness with divergent nozzles was about 30% higher. The divergent nozzle yielded a smaller spray torch angle. There are 2 figures and 3 tables.

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